

Abstract

The object of the present invention is to reliably ensure the compressive strength of the joint between a heat transfer pipe and a capillary tube when connecting the capillary tube to the heat transfer pipe by direct brazing. In the connection structure between the heat

5 transfer pipe (12) and the capillary tube (41), only the part on the opposite side of the pipe end face side of the cylindrical flared part (14) having a pipe diameter larger than that of the heat transfer pipe (12) formed in a pipe end part (12a) of the heat transfer pipe (12) is flatly crushed in the pipe latitudinal direction. Thereby, a pinched part (14a) wherein a tube end part (41a) of the capillary tube (41) is inserted from the pipe end face side of the flared part
10 (14), and a brazing filler material pooling part 14d for pooling on the pipe end face side of the pinched part (14a) the brazing filler material that flows into the pinched part (14a) are formed. Further, in a state inserted from the pipe end face side of the flared part (14) into the pinched part (14a), the tube end part (41a) of the capillary tube (41) is brazed to the heat transfer pipe (12).

15